

Date: Friday, 21/07/2006 12:04:53 PM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE SPACER	
Job Number	: 27969		Part Number	: D2885	
Estimate Number	: 10376		Drawing Number	: D2885 REV B	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 21/07/2006	S.O. No. : N/A	Drawing Revision	: B	
Prsh Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 07/08/2006 Qty: 40 Um: Each	
Previous Run	: 28026				
Written By	:				
Checked & Approved By	:				
Comment	: Est A 99.10.12 New Issue EC Est Rev:B Now 6060-T6 06-06-23 JLM Est Rev:C waterjet 06-07-23 ec				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S080	6061-T6 .080 Sheet  Comment: Qty.: 0.0270 sf(s)/Unit Total: 1.0794 sf(s) Material: 6061-T6 (QQ-A-250/8) 0.080" Thick Batch <u>M101178</u>
2.0	WATER JET	FLOW WATER JET  Prg. <u>B</u> Drw. <u>B</u> Comment: FLOW WATER JET <u>SAD 06:08:08</u> 40
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE  Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>SAD 06:08:08</u> 40
4.0	QC8	SECOND CHECK  Comment: SECOND CHECK <u>6/08/14</u> <u>P10</u> <u>39</u>
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1  Comment: HAND FINISHING RESOURCE #1 <u>SC 06/08/15</u> <u>39</u> Acid etch and Alodine as per QSI 005 4.1
5.0	delvng parts	- ml 06/08/14 <u>39</u>

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE SPACER

Job Number: 27969

Part Number: D2885

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



06-08-21

Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST393

06/08/22 09

8.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.08.23

Job Completion



06/08/22

PTD ->

Date: Tuesday, 7/18/2006 3:00:50 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE SPACER		
Job Number	: 27969					
Estimate Number	: 10376					
P.O. Number	:			Part Number	: D2885	
This Issue	: 7/18/2006		S.O. No. :	Drawing Number	: D2885 REV B	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type :	Drawing Revision	: B	
Previous Run	: 23926			Material	:	
Written By	:			Due Date	: 8/7/2006	
Checked & Approved By	: <u>DK</u> 06.07.19			Qty:	40	Um: Each
Comment	: Est A 99.10.2 New Issue EC					
	Est Rev:B Now 6060-T6 06-06-23 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6S080	6061-T6 .080 Sheet	
		Comment: Qty.: 0.0270 sf(s)/Unit Total : 1.0794 sf(s) Material: 6061-T6 (QQ-A-250/8) 0.080" Thick Batch _____	
2.0	SHEAR	SHEAR	
		Comment: SHEAR Blank: 7.90" x 3.50" (+0.030" - 0.000") 1 blank makes 4 parts	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine per folio D2885 2-Tumble 3-Deburr any rough edges after tumbling	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/08/14	4	1 Part scrup. Wash Set blow-dry + an hole.	J	destroy.	J.G 06/08/14	✓ 06-08-14	N/A	✓ 06-08-14

Part No: \_\_\_\_\_

PAR #: \_\_\_\_\_

Fault Category: \_\_\_\_\_

NCR: Yes  No DQA: 

Date: 06-08-23

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

Date: Tuesday, 7/18/2006 3:00:50 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE SPACER

Job Number: 27969

Part Number: D2885

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP
<b>Comment:</b> INSPECT WORK TO CURRENT STEP		
7.0	PACKAGING 1	PACKAGING RESOURCE #1
<b>Comment:</b> PACKAGING RESOURCE #1		
Identify and Stock		
Location: _____		
8.0	DC	DOCUMENT CONTROL
<b>Comment:</b> DOCUMENT CONTROL		
Inspection Level 21		

Job Completion



W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

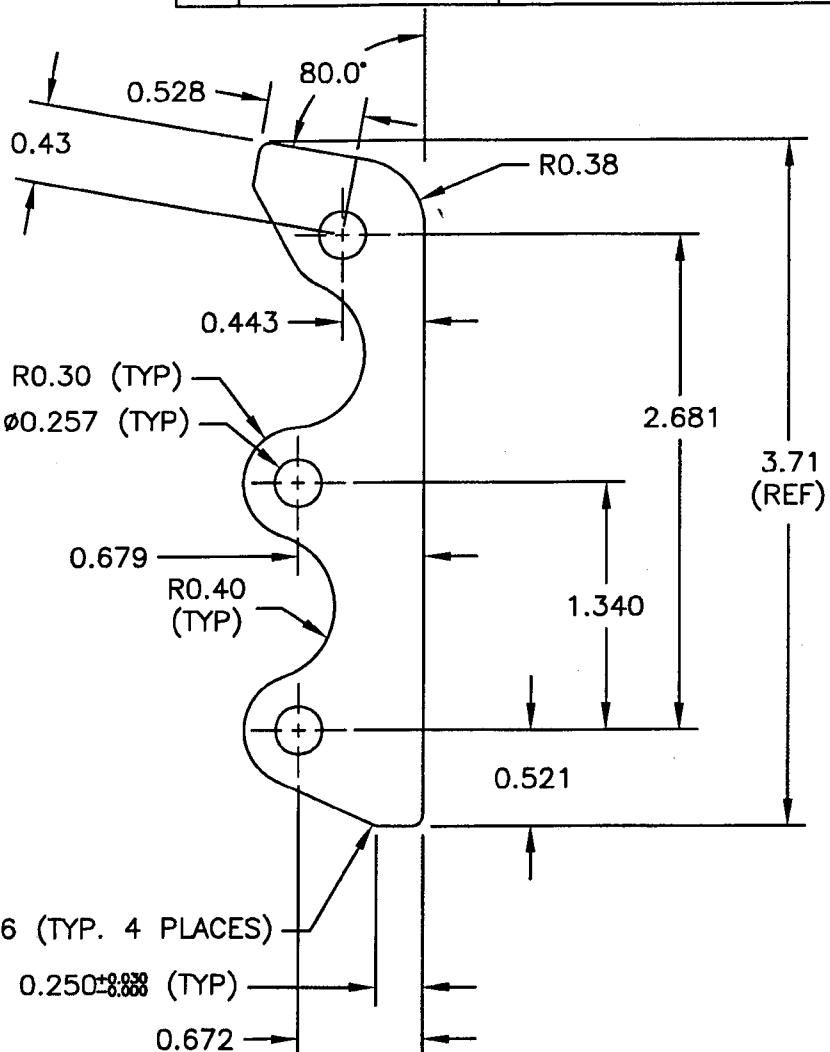
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2885
PH		REV. B SHEET 1 OF 1
DATE		SCALE 1:1
06.05.29		SADDLE SPACER
A	99.04.01	NEW ISSUE
B	06.05.29	ADD 6061-T6 MATERIAL



NOTES:

- MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027)  
0.080" THICK (REF DART SPEC M6061T6S.080)  
OR  
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016)  
0.080" THICK (REF DART SPEC M5052H32S.080)
- FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- BREAK ALL SHARP EDGES 0.010 TO 0.020
- ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 27969

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DART AEROSPACE LTD	Work Order:	27969
Description:	Part Number:	D2885
Inspection Dwg:	Rev:	B
		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      X Prototype

Measured by:	SAD	Audited by:	<del>J</del>	Prototype Approval:	<u>S</u> A.
Date:	06.08.08	Date:	06.08.14	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	